

303 R. 500

## Work Order ID 109117

November-11-13 1:55:54 PM

\*109117\*

Page 1

Item ID: D4072-5

Accept

\*N900040100\*

Setup

Start

\*NS1\*

Revision ID:

Item Name: Bushing

Stop

\*NS2\*

Start Date: 11/11/13 Start Qty: 60.00

\*60\*

Cust Item ID:

Required Date: 11/25/13 Req'd Qty: 60.00

\*60\*

Customer:

Reference:

Approvals: Process Plan: MLC

Date: 13-11-11

Tooling: \_\_\_\_\_

Date: \_\_\_\_\_

Run

Start

\*NR1\*

QC: \_\_\_\_\_

Date: \_\_\_\_\_

SPC (Y/N):

Date: \_\_\_\_\_

Stop

\*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
100		0.00							
*100*	Hardinge CNC LATHE SMALL								
Hardinge	Memo	0.00							
Hardinge CNC Lathe Small	1-Turn as per Dwg and Folio FA978 Dwg Rev: 13 Folio Rev: N/A								
	2-Deburr								
110	QC2- Inspect parts off machine FAI/FAIB	0.00							
*110*	Memo	0.00							
QC									
Quality Control									

60 Ø 13-11-26

60 Ø 13-11-26

DQA:

Date: \_\_\_\_\_



## WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed:

Date: \_\_\_\_\_

Work Order update only 

Work Order: _____			<b>DISPOSITION</b>		<b>AGAINST DEPARTMENT/PROCESS</b>						
			Rework <input type="checkbox"/>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	<b>Engineering</b>				
			Scrap <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coor. <input type="checkbox"/>	<b>Quality</b>				
			Use-as-is <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	<b>Other</b>				
			Suspected Unapproved <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>					
Root Cause	Date	Step	Qty	Description of work order update or non-conformance		Initial Chief Eng	Action Description		Sign & Date	Verification	QC Inspector
Design											
Doc/Data											
Equip/Tooling											
Handling/Pre											
Material											
Operator											
Offset/Setup											
Process											
Supplier											
Training											
Transport											
Unapproved											
<b>FAULT CATEGORY</b>											
Landing Gear				General							
Bending	Bend	Folio/Program	Outside Dimensions	Pressure/Forced							
Centre Not Concentric	BOM/Route	Grain	Over/Under tolerance	Set-up							
Cracks	Broken/Damage/Defect	Hardware	Part Incorrect	Temperature/Cure							
Crimp/Kink/Ripple/Wave	Burrs	Inspection Incomplete/Unqualified	Part Lost/Missing	Weld							
Cuffs	Contamination	Instructions Incomplete/Unclear	Part Moved	Wrong Stock Pulled							
Crushing	Countersink	Misaligned/off center	Positioned Wrong								
Heat Treat	Cut Too Short	Mislabeled	Power Loss/Surge	Other							
Inspection Strip in Tube	Drawing	Misread									
Marks/Chatter	Drill Holes	Off-set									
Turning Sequence	Finish	Out of Calibration									
Wave/Twist in Tube	Fit/Function	Out of Sequence									

Work Order ID 109117

November-11-13 1:55:54 PM

\*109117\*

Page 2

Item ID: D4072-5

Accept

\*N900040100\*

Setup

Start

\*NS1\*

Revision ID:

Stop

\*NS2\*

Item Name: Bushing

Start Date: 11/11/13 Start Qty: 60.00

\*60\*

Cust Item ID:

Required Date: 11/25/13 Req'd Qty: 60.00

\*60\*

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start

\*NR1\*

QC:

Date:

SPC (Y/N):

Date:

Stop

\*NR2\*

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

120

QC8- Inspect parts - second check

0.00

DAS  
40  
9.89

13/11/26

60

Ø

\*120\*

QC

Quality Control

130

Identify as per dwg & Stock Location: STC89

0.00

9.89

13/11/26

60

Ø

\*130\*

Packaging

Packaging

140

QC21- Final Inspection - Work Order Release

0.00

9.89

9.89

J/Rm 13/11/28

\*140\*

QC

Quality Control

PLB 11/24

DQA:

Date:



QA Closed:

Date:

## WORK ORDER NON-CONFORMANCE / UPDATE

Work Order update only 

Work Order:				<b>DISPOSITION</b>		<b>AGAINST DEPARTMENT/PROCESS</b>					
Part No.				Rework <input type="checkbox"/>	Scrap <input type="checkbox"/>	Use-as-is <input type="checkbox"/>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>	
NCR No.				Suspected Unapproved <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Finishing <input type="checkbox"/>	Prod. Eng. Coor. <input type="checkbox"/>	Quality <input type="checkbox"/>	
Design Doc/Data Equip/Tooling Handling/Pre Material Operator Offset/Setup Process Supplier Training Transport Unapproved	Date	Step	Qty	Description of work order update or non-conformance			Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
<b>FAULT CATEGORY</b>											
Landing Gear				<b>General</b>							
<input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube				<input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function	<input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence	<input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge	<input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled				

# Picklist Print

Page 1 / 1

November-11-13 1:55:58 PM

Work Order ID: 109117

**\*109117\***

Parent Item: D4072-5

**\*D4072-5\***

Parent Item Name: Bushing

Start Date: 11/11/13

Required Date: 11/25/13

Start Qty: 60.00

Required Qty: 60.00

Comments: IPP REV:A NEW ISSUE 10-10-08 JLM VERIFIED BY:DD  
REV:B DRAWING REV. CHANGE AS PER ECN 11-598  
VERIFIED BY:

IPP  
11-07-05 JFS

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M303R0.500  <b>*M303R0 500*</b> 303 Round Bar 0.500"		Purchased		No		100	f	77.4633	0.03	2	** <u>1.842</u>	<u>13-11-25</u>	

Location	Loc Qty	Loc Code
MAT028	77.46330000	
124081	1E-09	
124711	22.2	
125387	0.9033	
M126153	6.36	
M126689	48	<u>1.842</u>

DQA:

Date:



# **WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed:

Date:

## **Work Order update only**

Work Order: _____			DISPOSITION			AGAINST DEPARTMENT/PROCESS					
			Rework Scrap Use-as-is Suspected Unapproved	Skid-tube Machining Thermoforming Large Fab	Crosstube Small Fab Finishing Composite	Water Jet Prod. Eng. Coor. Rec/Store/Packaging Supplier	Engineering Quality Other				
Part No. _____											
NCR No. _____											
Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector		
Design											
Doc/Data											
Equip/Tooling											
Handling/Pre											
Material											
Operator											
Offset/Setup											
Process											
Supplier											
Training											
Transport											
Unapproved											
FAULT CATEGORY											
Landing Gear			General								
Bending	Bend	Folio/Program	Outside Dimensions	Pressure/Forced							
Centre Not Concentric	BOM/Route	Grain	Over/Under tolerance	Set-up							
Cracks	Broken/Damage/Defect	Hardware	Part Incorrect	Temperature/Cure							
Crimp/Kink/Ripple/Wave	Burrs	Inspection Incomplete/Unqualified	Part Lost/Missing	Weld							
Cuffs	Contamination	Instructions Incomplete/Unclear	Part Moved	Wrong Stock Pulled							
Crushing	Countersink	Misaligned/off center	Positioned Wrong								
Heat Treat	Cut Too Short	Mislabeled	Power Loss/Surge								
Inspection Strip in Tube	Drawing	Misread									
Marks/Chatter	Drill Holes	Off-set									
Turning Sequence	Finish	Out of Calibration									
Wave/Twist in Tube	Fit/Function	Out of Sequence									

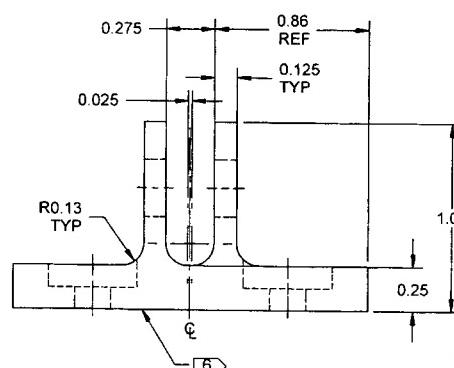
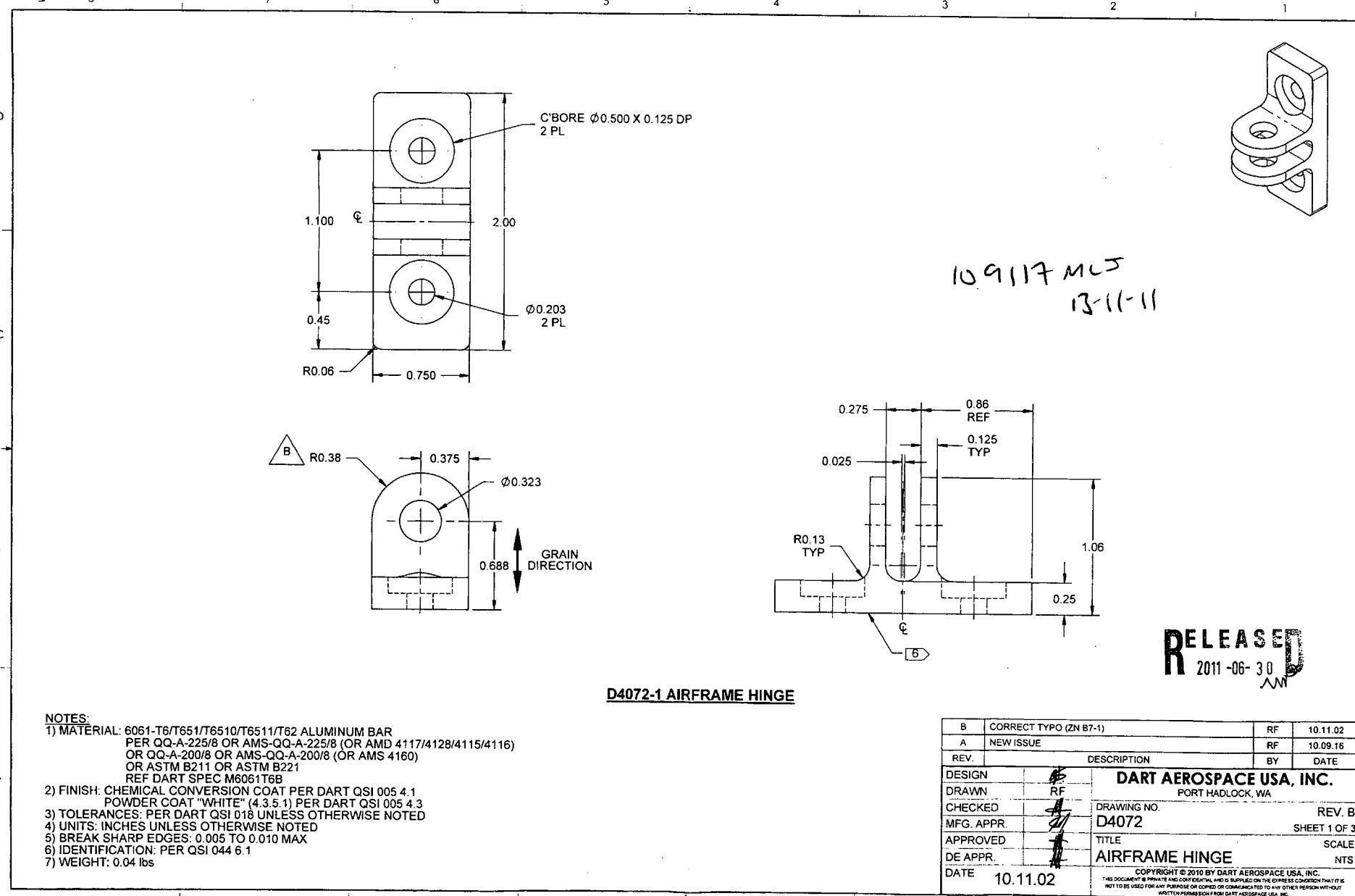
DART AEROSPACE LTD	Work Order:	109117
Description: Bushing	Part Number:	D4072-5
Inspection Dwg: D4072	Rev: B	Page 1 of 1

## **FIRST ARTICLE INSPECTION CHECKLIST**

Measured by:	<i>SL</i>	Audited by:	<i>40</i> <small>9-29</small>	Preliminary Approval:	
Date:	<i>13-11-25</i>	Date:	<i>13/11/26</i>	Date:	

<b>Rev</b>	<b>Date</b>	<b>Change</b>	<b>Revised by</b>	<b>Approved</b>
A	10.10.25	New Issue	KJ	
B	11.07.26	Dwg Rev updated	KJ	

8 7 6 5 4 3 2 1



**RELEASED**  
R 2011-06-30 AM

B	CORRECT TYPO (ZN B7-1)	RF	10.11.02
A	NEW ISSUE	RF	10.09.16
REV.	DESCRIPTION	BY	DATE
DESIGN	<i>5</i>		
DRAWN	RF		
CHECKED	<i>A</i>		
MFG. APPR.	<i>2</i>		
APPROVED	<i>1</i>		
DE APPR.	<i>1</i>		
DATE	10.11.02	SCALE	NTS

**DART AEROSPACE USA, INC.**  
PORT HADLOCK, WA

REV. B  
DRAWING NO.  
**D4072**  
SHEET 1 OF 3  
TITLE  
**AIRFRAME HINGE**

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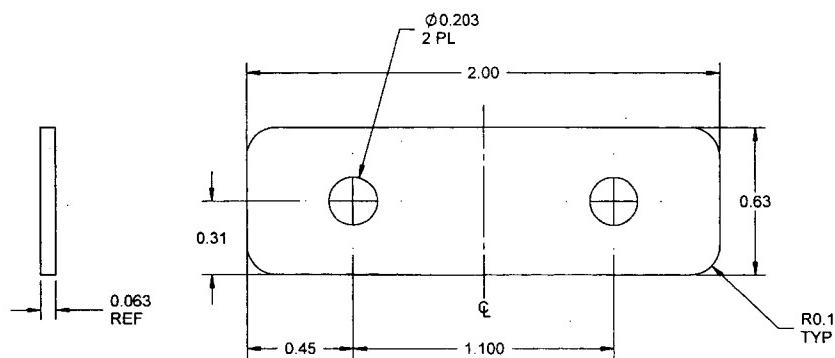
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D4072-3 AIRFRAME HINGE BACKING PLATE

RELEASED  
2011-06-30  
M

NOTES:

- 1) MATERIAL: 6061-T6/T62 ALUMINUM SHEET, 0.063 THICK  
PER QQ-A-250/11 OR AMS-QQ-A-250/11  
OR AMS 4025 OR AMS 4027  
OR ASTM B209  
REF DART SPEC M6061T6S.063
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT "WHITE" (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: PER QSI 044 6.1
- 7) WEIGHT: 0.01 lbs

DESIGN	RF	DART AEROSPACE USA, INC.
DRAWN	RF	PORT HADLOCK, WA
CHECKED	RF	DRAWING NO.
		D4072
MFG. APPR.	RF	REV. B
APPROVED	RF	SHEET 2 OF 3
DE APPR.	RF	TITLE
DATE	10.11.02	SCALE
		NTS
		AIRFRAME HINGE

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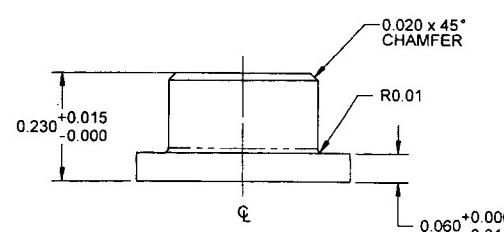
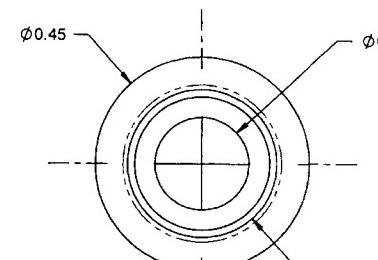
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D4072-5 BUSHING

RELEASED  
R 2011-06-30  
*[Handwritten signature]*

NOTES:

- 1) MATERIAL: AISI 303 STAINLESS STEEL BAR  
REF DART SPEC. M303B
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: PER QSI 044 6.1
- 7) WEIGHT: 0.004 lbs

DESIGN	RF	DART AEROSPACE USA, INC.	
DRAWN	RF	PORT HADLOCK, WA	
CHECKED	#		
MFG. APPR.	#	DRAWING NO. D4072	
APPROVED	#	REV. B SHEET 3 OF 3	
DE APPR.	#	TITLE AIRFRAME HINGE	
DATE	10.11.02	SCALE NTS	

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